

Work Order ID 75223

75223

Page 1

October-19-11 11:09:00 AM

Item ID: D2803-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 19/10/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2803	Rev B

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100 FLOW WATER JET
 Waterjet
 FLOW CNC Waterjet
 604 .500X 10"
 Memo
 1-Cut as per file d2803-2
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary
 11-10-21
 (7)

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Machine as per folio FA102
 SL 11-11-14
 6 (4) 11-10-21
 (PTC) →

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120 QC2- Inspect parts off machine FAI/FAIB
 QC
 Quality Control
 Memo
 SL 11-11-14
 (4) 11-10-21

W/O:		75223 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D28032 PAR #: _____ Fault Category: Small FAB NCR: (Yes) No DQA: u Date: 11/11/15
water jet
Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/11/16

NCR: <u>11-985</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>11-16275</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.11.14	100	Stack material too small for one piece. Edge distance for one attaching loss has flat. RL Process	<u>S</u> 11/11/14 Q57012	G.032 under below nominal SCRAP. <u>Q11.11.14</u> NO Rep/ae Qty 4/	<u>SL</u> 11-11-14	<u>enl</u> 11/11/14	<u>S</u> 11/11/14 Q57012	<u>S</u> 11/11/14

NOTE: Date & initial all entries

Work Order ID 75223

October-19-11 11:09:00 AM

75223

Page 2

Item ID: D2803-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 19/10/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

145

QC3- Inspect Part Finish

0.00

145

QC

Memo

0.00

Quality Control

cm 11/11/14

6 8

6 BR 11-11-14

6XØ m. 11/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75223

Page 3

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 19/10/2011 **Start Qty:** 6.00 ***6***

Required Date: 07/11/2011 **Req'd Qty:** 6.00 ***6***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150 Identify as per dwg & Stock Location: ST/48 0.00

150

Packaging	Memo	0.00
-----------	------	------

Packaging

160	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

160

QC	Memo	0.00
----	-------------	------

Quality Control

PHHS
CW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-19-11 11:09:06 AM

Page 1

Work Order ID: 75223

75223

Parent Item: D2803-2

D2803-2

Parent Item Name: Bracket

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 00.11.06New IssueEC
 IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM
 IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC IPP
 Rev:D add qc3 DD 10.02.19 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	6.9249	1.9167	12.10547	14,		

M6061T6B0 500X10 000

6061-T6 Bar .500 x 10.00

**

BK-10-21

Location

Loc Qty

Loc Code

MAT004

6.9249

118271

6.9249

11382

119346

118271
11382

119346

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

259 633 749
780

DART AEROSPACE LTD		Work Order: 75223
Description: Bracket		Part Number: D2803-2
Inspection Dwg: D2803 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	759	✓		Vern JL3	
1.420	+/-0.001	1.420	✓		"	
Ø0.191	+0.005/-0.000	.192	✓		"	
Ø0.507	+0.000/-0.001	.5062	✓		mic JL4	
Ø0.507 x 0.250	+0.000/-0.001	.5062 x .246	✓		Vern JL3	
12.411	+/-0.010	12.411	✓			
6.933	+/-0.010	6.933	✓		Vern CNC-02	
0.250	+/-0.010	.251	✓			
0.875	+0.000/-0.001	.8747	✓		mic JL4	
0.250	+0.000/-0.005	.248	✓		HG	
0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.125	✓			
0.500	+/-0.010	.503	✓			
0.125	+/-0.010	.119	✓			
0.188	+/-0.010	.188	✓			
0.562	+/-0.010	.563	✓			
0.125	+/-0.010	.123	✓			

Measured by:	JL
Date:	11/11/13

Audited by:	QML
Date:	11/11/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

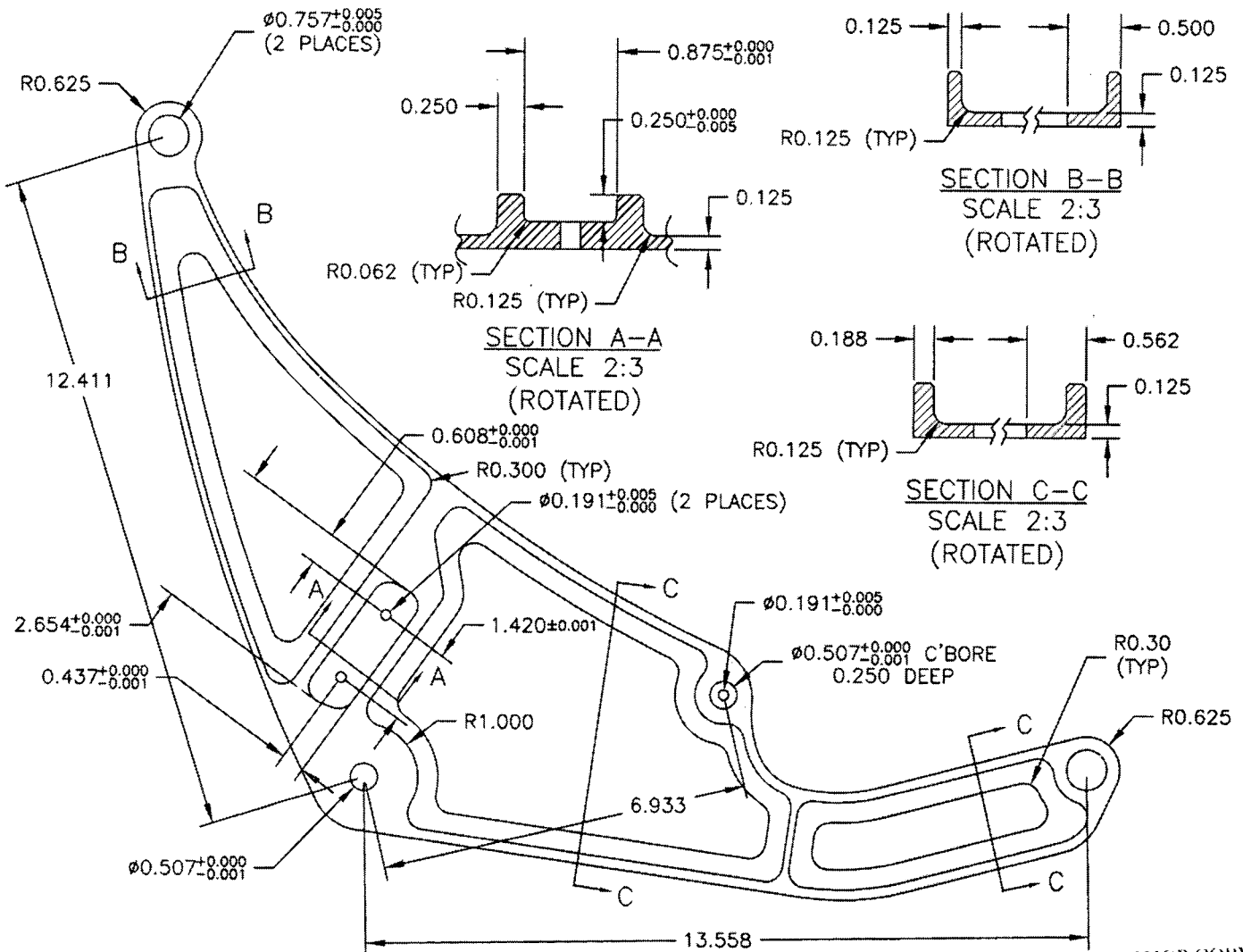
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER 142.5
NO. 75223
11/10/19

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

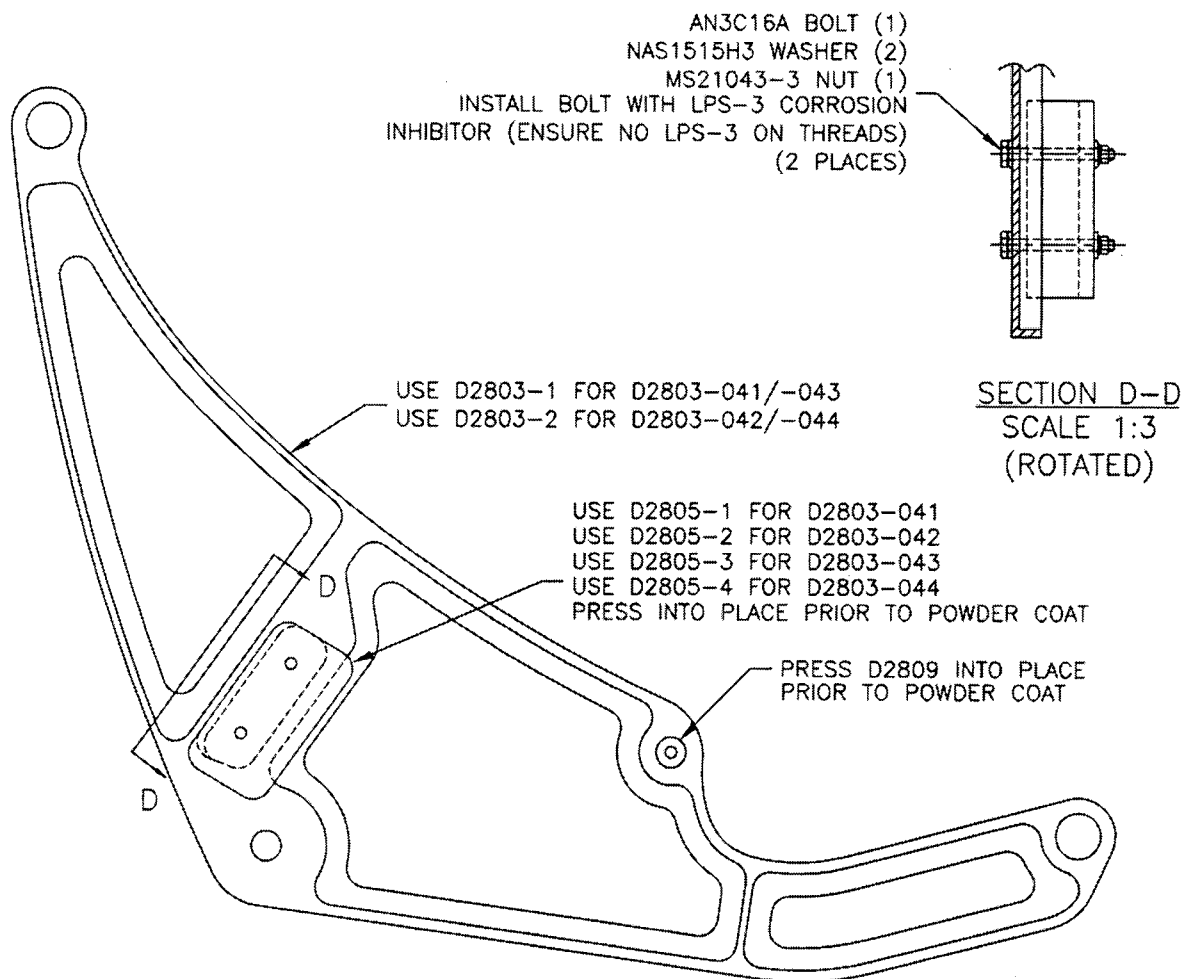
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11 [Signature]

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

75223

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries